

Date: Wednesday, 6/28/2006 4:18:34 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 27756C		
Estimate Number	: 10354		
P.O. Number	: <i>N/A</i>	Part Number	: D2322
This Issue	: 6/28/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2322 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 25395C	Material	: <i>N/A</i>
Written By	: <i>See Comment Below</i>	Due Date	: 7/12/2006
Checked & Approved By	: <i>06 06 29</i>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 05-11-07 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2132 sf(s)/Unit Total : 4.2630 sf(s)  
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick  
 (M2024T3S.040)  
 Identify as D2322  
 Batch: *M19295*

2.0	SHEAR	SHEAR
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Comment: SHEAR  
 Cut blanks: (6.520" x 4.500") +/- 0.010" (grain along 4.500")

3.0	<del>HAAS1</del> <i>Water Jet</i>	HAAS CNC VERTICAL MACHINING #1
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Comment: ~~HAAS CNC VERTICAL MACHINING #1~~  
 Machine as per folio D2322, *was 25395*

*Dwg Rev: C*

*Proj Rev: C*

*SAD 08:07:11 (20)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 08:07:11 (20)*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SAD 08:07:13 (18)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27756C		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.07.11	3.	3 pieces w holes of 3 pieces were to <del>scrap</del> Big from the water Jet. wrong TIP operator error		Scrap and destroy replace	SAD 06.07.11			
06.07.13	3	2 parts scrap. w. J. damage around the holes.		Scrap & destroy.	 06.07.13			
06.07.19	7	1 part was out of tolerance		Scrap + destroy	SB 06.07.19			

Part No: D2322

PAR #: WLA

Fault Category: Prod / machined parts

NCR:

Yes

No

DQA:

Date: 06/08/01

NOTE: Date &amp; initial all entries

QA: N/C Closed:

Date: 06.08.02

Date: Wednesday, 6/28/2006 4:18:34 PM  
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 27756C

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Debur

SAD 06/07/14

(18)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2322

SB 06/07/19

(17)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/07/20

(17)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/07/20

(12)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/07/21

(17)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD 06/07/31

17

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/01

Job Completion



C206/08/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2322	REV. C SHEET 1 OF 1
DATE 98.09.29	TITLE STEP SPACER		SCALE 1:2
A	94.10.14	NEW ISSUE	
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001	

RELEASED  
18.10.08 DS

UNDER REVIEW

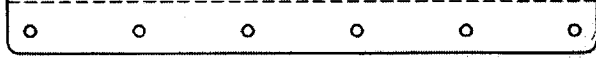
12.03.15 CP

DESIGN OK BUT CHECK WITH  
DTS BEFORE MANUFACTURE

OK 6P 04.11.9

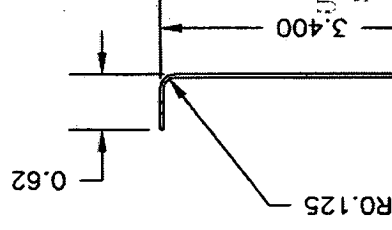
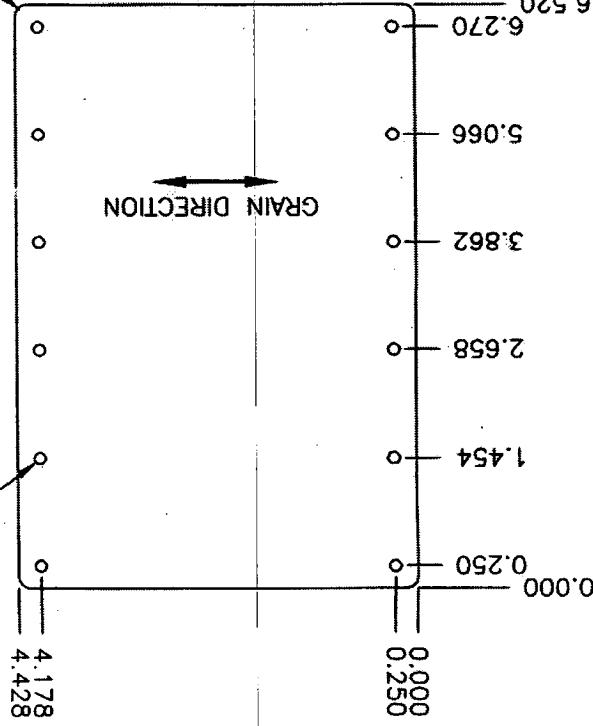
Ø0.128 (TP 12 PLACES)

Ø0.125 (TP 4 PLACES)



GRAIN DIRECTION

FLAT LAYOUT



MATERIAL: 2024-T3 (00-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 27756C

Date: Tuesday, 04/07/2006 9:10:16 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 27756C		
Estimate Number	: 10354		
P.O. Number	: <i>N/A</i>	Part Number	: D2322
This Issue	: 04/07/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2322 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 28/06/2006 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 25395C	Material	: <i>N/A</i>
Written By	: <i>SEE COMMENT BELOW</i>	Due Date	: 12/07/2006
Checked & Approved By	: <i>[Signature]</i>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 05-11-07 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick  
 (M2024T3S.040)  
 Identify as D2322  
 Batch: *M19295*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

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Seq. #: Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2322

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

